

Date: Friday, 01/05/2009 11:19:31 AM
 User: Linda Lacelle

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	HI-STEP LEG ASSEMBLY
Job Number :	47644		
Estimate Number :	10355		
P.O. Number :		Part Number :	D2582
This Issue :	01/05/2009	Drawing Number :	D2582 REV B
Prsht Rev. :	NC	Project Number :	N/A
First Issue :	01/05/2009	Drawing Revision :	B
Previous Run :	44293	Material :	
Written By :		Due Date :	10/05/2009
Checked & Approved By :	<u>JLD 09.05.01</u>	Qty:	10
Comment :	Est Rev:F Removed Manufacturing 05-11-07 JLM	Um:	Each
	Est Rev:G Added part # to Sub 06-08-10 JLM		
	Est Rev H New pick list 08.01.11 EC verified		
	by: DD		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	47644A	STEP LEG
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Comment: Sub-Component STEP LEG

2 x D2278 Batch B 47644 A

B 44293 (3x)

Epo 09/05/12

2.0	47644B	STEP SPACER
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Comment: Sub-Component STEP SPACER

1 x D2322 Batch B 44293 (9x)

B 47644 (N)

Epo 09/05/12

3.0	47644C	STEP SPACER
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Comment: Sub-Component STEP SPACER

1 x D2279 Batch B 31407 (8x)

B 37925 (2x)

Epo 09/05/12

4.0	47644D	STEP SPACER
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Comment: Sub-Component STEP SPACER

1 x D3720-1 Batch B 44293 (6x)

B 44693 (4x)

Epo 09/05/12

5.0	47644E	STEP SPACER
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Comment: Sub-Component STEP SPACER

1 x D3720-2 Batch B 44293 (7x)

B 44694 (3x)

Epo 09/05/12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 01/05/2009 11:19:31 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HI-STEP LEG ASSEMBLY

Job Number: 47644

Part Number: D2582

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

MS20470AD44

Rivet, Universal Head



Comment: Qty.: 22.0000 Each(s)/Unit Total : 220.0000 Each(s)

Pick:

Qty Part Number Description Batch
22 MS20470AD4-4 Rivet *M111193*

7.0

MS20470AD45

Rivet, Universal Head



Comment: Qty.: 4.0000 Each(s)/Unit Total : 40.0000 Each(s)

Pick:

Qty Part Number Description Batch
4 MS20470AD4-5 Rivet *M109031*

8.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1
Assemble as per Dwg D2582 and

9.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1
Identify and Stock
Location: *WA*

11.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion




MF 09-05-12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
								

NOTE: Date & initial all entries

D2278 STEP LEG
(2 PLACES)

MS20470AD4-4 RIVET
(5 PLACES PER SIDE)
(INSTALL FROM OUTSIDE OF ASSEMBLY)

D2278 STEP SPACER

D2322 STEP SPACER

MS20470AD4-4 RIVET
(6 PLACES PER SIDE)
(INSTALL FROM OUTSIDE OF ASSEMBLY)

D2582 STEP LEG ASSEMBLY

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER NO. 27694

D2582 STEP LEG ASSEMBLY PARTS LIST

QTY	PART NUMBER	DESCRIPTION
X	D2582	STEP LEG ASSEMBLY
2	D2278	STEP LEG
1	D2279	STEP SPACER
1	D2322	STEP SPACER
1	D3720-1	STEP SPACER
1	D3720-2	STEP SPACER
22	MS20470AD4-4	RIVET
4	MS20470AD4-5	RIVET

NOTES:

- 1) FINISH: NONE
- 2) IDENTIFICATION: IDENTIFY WITH DART P/N "D2582" USING FINE POINT PERMANENT INK MARKER WHERE INDICATED
- 3) WEIGHT: 1.25 lbs

MS20470AD4-5 RIVET
(2 PLACES)

D3720-2 STEP SPACER

C'SINK ON INSIDE
GRIND RIVET FLUSH TO
SURFACE AS REQUIRED
(BOTH SIDES)

MS20470AD4-5 RIVET
(2 PLACES)

D3720-1 STEP SPACER

RELEASED
05-01-10

B	REPLACE D2280 SPACERS WITH D3720-1/-2 SPACERS REFERENCE NCR 263 UPDATE DRAWING FORMAT	PH	07.12.27
A	NEW ISSUE	CP	01.10.05
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN	PH		
CHECKED	LE		
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	07.12.27		

DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWING NO. D2582	REV. B SHEET 1 OF 1
TITLE STEP LEG ASSEMBLY	SCALE NTS
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